

Work Order ID 74041

Tuesday, September 20, 2011 4:15:15 PM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Item Name: Rear Locker Extender

Stop



Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-09-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2273 | D | | | | | | | | |
| D350-604-041 | A | | | | | | | | |
| DSI9470 | A | | | | | | | | |

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14968
Description: D350-604-041 Rear locker extender.
Supplier: Delastek.
Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 11 8800

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 74041

Page 3

Tuesday, September 20, 2011 4:15:15 PM

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|--|----------------------|---------|------------|--------------|---------------|---------------|------------------|--------------------|
| 150 QC Quality Control | QC4- 100% Inspect kits for completeness Memo | 0.00 0.00 | | 5 11/10/27 | | (X) | | | |
| 160 Packaging Packaging | Packaging Memo Identify and pack for shipping as per PPP D350-604-041 Location: _____ PPP Rev: _____ | 0.00 0.00 | | | | | | | |
| 170 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | MF 11-10-27 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |





NOTE: Date & initial all entries

Tuesday, September 20, 2011 4:15:21 PM

[illegible]**Required Date:** 10/21/2011

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| 2600-6  | | Purchased | No | | | 110 | Each | 303.0000 | 4 | 4 | | | |
| Camlock Stud | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST380 | | | | 303 | | | | | |
| | | | | 118611 | | | | 1 | | | | | |
| | | | | 118752 | | | | 16 | | | | | |
| | | | | 118800 | | | | 196 | | 118800 | | | |
| | | | | 118852 | | | | 90 | | | | | |
| D350-604-041P  | | Purchased | No | | | 120 | Each | 0.0000 | 1 | 1 | | | |
| Rear Locker Extender | | | | | | | | | | | | | |
| D2268  | | Manufactured | No | | | 140 | Each | 15.0000 | 1 | 1 | | | |
| Decal | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST010 | | | | 15 | | | | | |
| | | | | 69592 | | | | 5 | | | | | |
| | | | | 72054 | | | | 10 | | 72054 | | | |
| D2269  | | Manufactured | No | | | 140 | Each | 12.0000 | 1 | 1 | | | |
| Decal | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST010 | | | | 12 | | | | | |
| | | | | 67421 | | | | 2 | | | | | |
| | | | | 72055 | | | | 10 | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

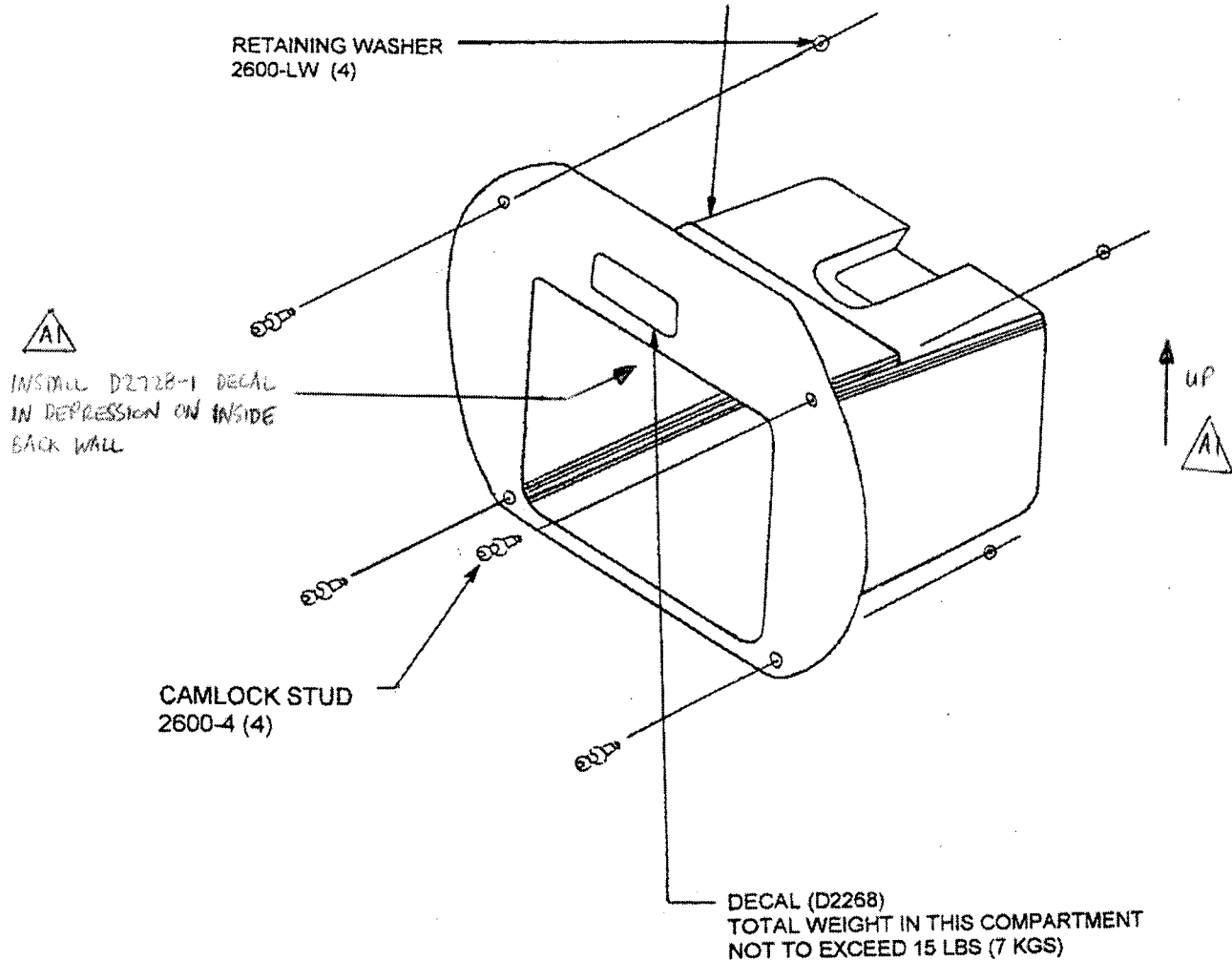
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------------|-------------------------|--|------------------------|
| DESIGN BW | DRAWN BY UP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D350-604-041 | REV. A SHEET 1 OF 1 |
| DATE 02.04.01 | | TITLE REAR LOCKER EXTENDER ASSEMBLY | SCALE NTS |
| A | 02.04.01 | NEW ISSUE | |
| A1 | RF 02.04.23 | ADD D2728-1 DECAL + ORIENTATION NOTE REAR LOCKER EXTENDER (D2273) | |

RELEASED
02.04.03



D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

| | |
|------------|---------|
| Invoice # | 40831 |
| Customer # | DART US |

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

| Ship via | | F.O.B. | | Terms | | Salesperson | |
|------------------|------------|---------------|-----------------|--|-----------|--------------------------|--|
| FEDEX P1 Collect | | Origin | | Net 30 days USA | | Claude Lessard, ext. 233 | |
| Ship date | Order Date | Our PO # | Order by | | Your PO # | GST/PST # | |
| 21/10/2011 | 21/09/2011 | 18754 | Brigitte Golden | | PO14968 | | |
| Order Qty | B.O. Qty | Current Ship. | Item # | Item Description | | | |
| 1 | 0 | 1 | DKC134-0003 | Line #1 Rear Locker Extender D350-604-041P B74042 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <div><div>No. série</div><div>No. lot</div><div>B74041</div><div>36516</div></div> <div>S u/10/27</div> | | | |
| 1 | 0 | 1 | DKC134-0003 | Line #2 Rear Locker Extender D350-604-041P B74041 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <div><div>No. série</div><div>No. lot</div><div>B74042</div><div>35979</div></div> <div></div> | | | |

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Vendredi, 2011-10-14 15:59:03
 Utilisateur: Pascal Carignan

Feuille de Procédé

| | | | | | |
|---------------------|----------------------------|------------|-------------------|-------------------------|-------------------|
| Client : | DART US DART AEROSPACE LTD | | Nom Dessin : | REAR LOCKER EXTENDER | |
| Numéro Job : | 36516 | | Numéro Article : | DKC134-0003 | |
| Numéro Soumission : | 3482 | | Numéro Dessin : | D350-604-041 & D2273 | |
| Numéro B.A. : | Kit 860 | | Projet Numéro : | DK-362 | |
| Cette fois : | 2011-10-14 | No. B.V. : | Révision dessin : | A & D | |
| Prsht Rev. : | NC | | Matériel : | Derakane 470-36/411/510 | |
| Prem. fois : | Type : | | Date Dûe : | 2011-10-21 | Qté: 1 Udm: UNITE |
| Job précédente : | 35979 | | | | |

 Écrit par : _____
 Vérifié & Approuvé par : _____
 Commentaires : N° de pièce Laminée Dart Aerospace: D2273
 N° de pièce Assemblage Dart Aerospace: D350-604-041

B 74041

Process Sheet Rév.: 03 Modifier la seq. 6 Prep-general.

Produit additionnel

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------------|----------------------|
| 1.0 | PRÉPARATION | Préparation du moule |
|-----|-------------|----------------------|



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: 18-10-11 Sceau:



| | | |
|-----|---------|-------------------------------|
| 2.0 | AMB0350 | Gel Coat Blanc N° Gel 944W005 |
|-----|---------|-------------------------------|

Commentair Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)

Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-32675-1

| | | |
|-----|---------|-------------------|
| 3.0 | AMB0286 | Catalyst N° DDM-9 |
|-----|---------|-------------------|

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-27829-1

| | | |
|-----|--------|---------|
| 4.0 | AC0747 | Acetone |
|-----|--------|---------|

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

| | | |
|-----|--------------|-------------------------|
| 5.0 | PRÉP-GENERAL | Préparation du matériel |
|-----|--------------|-------------------------|



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 18-10-11 Sceau:



Date: venoedi, 2011-10-14 15:59:03
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36516

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

6.0

REP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du Gel coat selon IF134-0003 .

Date: 18-10-11 Sceau:



7.0

GEL COAT

Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 18-10-11 Sceau:



8.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-32577-2

9.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

10.0

AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-31000-2

11.0

AMB0213

WR1850 Roving 18oz x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot: 1-28778-1

12.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:

Humidité: 28% Température: 67.5 Heure: 3:00

Quantité: 1 Date: 18-10-11 Sceau:



Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36516

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

13.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total : 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-32577-2

14.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-29829-1

15.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon IF134-0003 si applicable.

Quantité: _____

Date: _____

Sceau: _____

16.0

DEMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire le démoulage de la pièce selon IF134-0003 en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager .

Quantité: 1

Date: 20-10-11

Sceau: _____



17.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon IF 134-0002.

Faire le sablage si nécessaire.

Quantité: 1

Date: 20-10-11

Sceau: _____



18.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.3400 UNITE(s)/Unit Total : 0.3400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot:

1-30270-1

19.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot:

1-31394-2

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36516

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

20.0


PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.

Quantité: 1 Date: 20 Oct 11 Sceau:  N° fiche de Mélange: N/A

21.0

AAC1607

Camlock Stud 2600-4 (or Monadnock 1126000-4)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: +33 1-32365-1

22.0

AAC0682

Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot: 1-6688-1

23.0

ASSEMBLAGE

Assemblage mécanique




Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'assemblage selon IF134-0004.

Démasker la pièce.

Assembler les "Studs" selon IG 0037.

Quantité: 1 Date: 21-10-11 Sceau: 

24.0

IDENTIFICATION

Identification à encre indélébile




Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'identification de la pièce selon IF134-0005.

N° de pièce Cleint: D350-604-041

N° de Job: 36516

N° de Fabrication: 21/10/2011

Quantité: 1 Date: 21/10/2011 Sceau: 

25.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36516

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:



Description :

Quantité: 1 Date: 21-10-11 Sceau:

26.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.



Quantité: 1 Date: 21-10-11 Sceau:

fab 21 oct-11

Job 36516